

Work Order ID 58849

Wednesday, May 19, 2010 1:40:45 PM



Page 1

Item ID: D3908-3	Accept		Setup	Start	
Revision ID:					
Item Name: Stud Receiver, Lower				Stop	
Start Date: 5/19/2010	Start Qty: 10.00				
Required Date: 5/26/2010	Req'd Qty: 10.00				
Reference:					

Approvals:	Process Plan: <u>PL</u>	Date: <u>10-5-19</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D3908	B								

100	Cut blanks as per folio	0.00							
Bandsaw	Memo	0.00	<u>amk 10/05/27</u>			<u>3</u>	<u>0</u>		
Jeaspa Bandsaw	CUT BLANK 4.00" LONG								

110		0.00							
HAAS 1	Memo	0.00	<u>amk 10/06/01</u>			<u>3</u>	<u>0</u>		
HAAS CNC vertical machine #1	MACHINE AS PER FOLIO FA866 AND DWG								
	FOLIO REV: <u>44</u>								
	DWG REV: <u>B</u>								
	DEBURR								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Revision ID:
Item Name: Stud Receiver, Lower
Start Date: 5/19/2010 Start Qty: 10.00 Cust Item ID:
Required Date: 5/26/2010 Req'd Qty: 10.00 Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start
QC: Date: SPC (Y/N): Date: Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	mk 10/06/01			3	0		
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	mk 10/06/02			3	0		
160 Packaging Packaging	Identify as per dwg & Stock Location: <u>ST</u> Memo	0.00 0.00				mk 10-6-02			

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Item ID: D3908-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Stud Receiver, Lower

Start Date: 5/19/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 5/26/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/02

MF 10-6-02

Dart Aerospace Ltd

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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 19, 2010 1:40:50 PM

Page 1

Work Order ID: 58849



Parent Item: D3908-3



Parent Item Name: Stud Receiver, Lower



Start Date: 5/19/2010

Required Date: 5/26/2010

Comments: IPP REV:A NEW ISSUE 09-11-24 JLM VERIFIED BY:DD IPP Rev:B
as per dwg revB DD 10.04.20 verified by:EC

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M303B1.000X2.000		Purchased	No			100	f	1.4842	0.333333			
												
303 BAR 1" X 2"												

Location

Loc Qty

Loc Code

MAT53

1.48417

113390

1.48417

1.48417 *OK 10/05/27*

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	58840
Description: Stud Receiver Lower		Part Number:	D3908-3
Inspection Dwg: D3908	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.25	+0.005/-0.001	Ø.251	/			
0.625	+/-0.010	.627	/			
0.368	+/-0.010	.365	/			
Ø0.453	+0.010/-0.000	Ø.454	/			
1.95	+/-0.030	1.941	/			
Ø0.38	+0.006/-0.001	Ø.379	/			
0.63	+/-0.030	.624	/			
2.43	+/-0.030	2.422	/			
0.63	+/-0.030	.624	/			
0.75	+/-0.030	.749	/			
0.38	+/-0.030	.375	/			
R0.06	+/-0.030	R.060	/			
R0.25	+/-0.030	R.250	/			
3.80	+/-0.030	3.800	/			
0.735	+0.000/-0.010	.729	/			
Ø0.129	+0.005/-0.001	Ø.129	/			
1.25	+/-0.030	1.250	/			
15°	+/-0.5°	15°	/			
1.587	+/-0.010	1.582	/			
1.588	+/-0.010	1.582	/			
0.31	+/-0.030	.312	/			
0.750	+/-0.010	.751	/			
0.95	+/-0.030	.950	/			
0.99	+/-0.030	.990	/			
90°	+/-0.5°	90°	/			
0.06 x 45°	+/-0.030 x 0.5°	.060 x 45°	/			
0.80	+/-0.030	.800	/			

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Preliminary Approval:	
Date:	10/06/01	Date:	10/06/02	Date:	

Rev	Date	Change	Revised by	Approved
A	10.04.01	New Issue	KJ	
B	10.04.20	Dwg Rev updated	KJ	<i>[Signature]</i>

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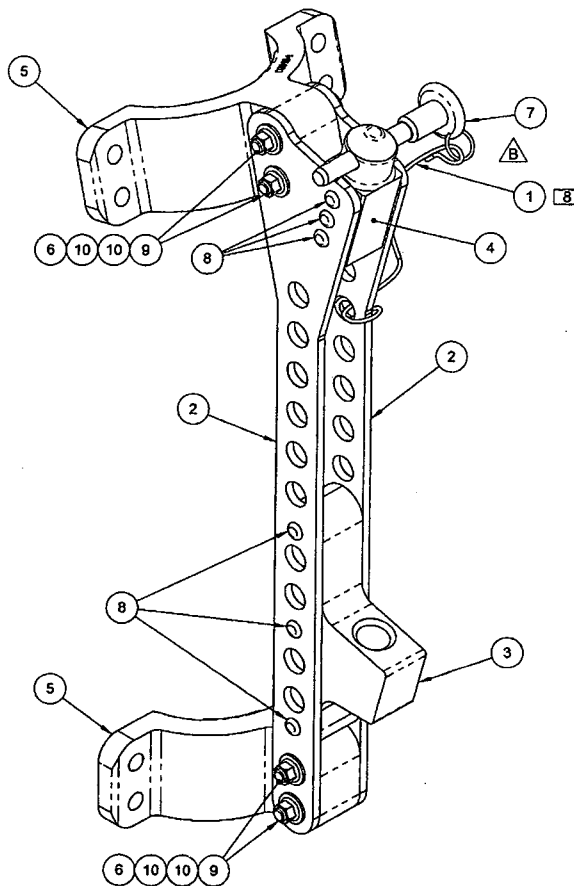
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NOTE: Date & initial all entries

ITEM	QTY.	P/N	DESCRIPTION
	X	D3908-041	X-TUBE LUG ASSY (AFT)
1	1	D2690-6	LANYARD
2	2	D3908-1	AFT X-TUBE LUG PLATE
3	1	D3908-3	STUD RECEIVER LOWER
4	1	D3908-5	EYEBOLT STUD
5	2	D3910-1	X-TUBE LUG
6	4	AN3C12A	BOLT
7	1	MS17984-C413	PIP PIN
8	6	MS20615-4M20	RIVET
9	4	MS21043-3	NUT
10	8	NAS1149C0332R	WASHER



D3908-041 X-TUBE LUG ASSY (AFT)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3908-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.35 lbs
- 8) ATTACH TO D3908-1 BY LOOPING AROUND LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING.

SH...
RE...
ENGINE...
UNCONTROLLED...
SUBJECT TO AMERICAN...
WITHOUT NOT...
WORK ORDER...
NO. 58849
BJ10-5-19

RELEASED
2010-04-14
NP

B	BOM: D3908-5 REPLACED WITH D3908-5. QTY 1 ADDED: D2690-6 & MS17984-C413. SHEET 5: ADDED D3908-5		JPH	10.04.06
A	NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION		BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	JPH			
CHECKED	JPH	DRAWING NO. D3908	REV. B	
MFG. APPR.			SHEET 1 OF 5	
APPROVED		TITLE	SCALE	
DE APPR.		X-TUBE LUG ASSY (AFT)	NTS	
DATE	10.04.06		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

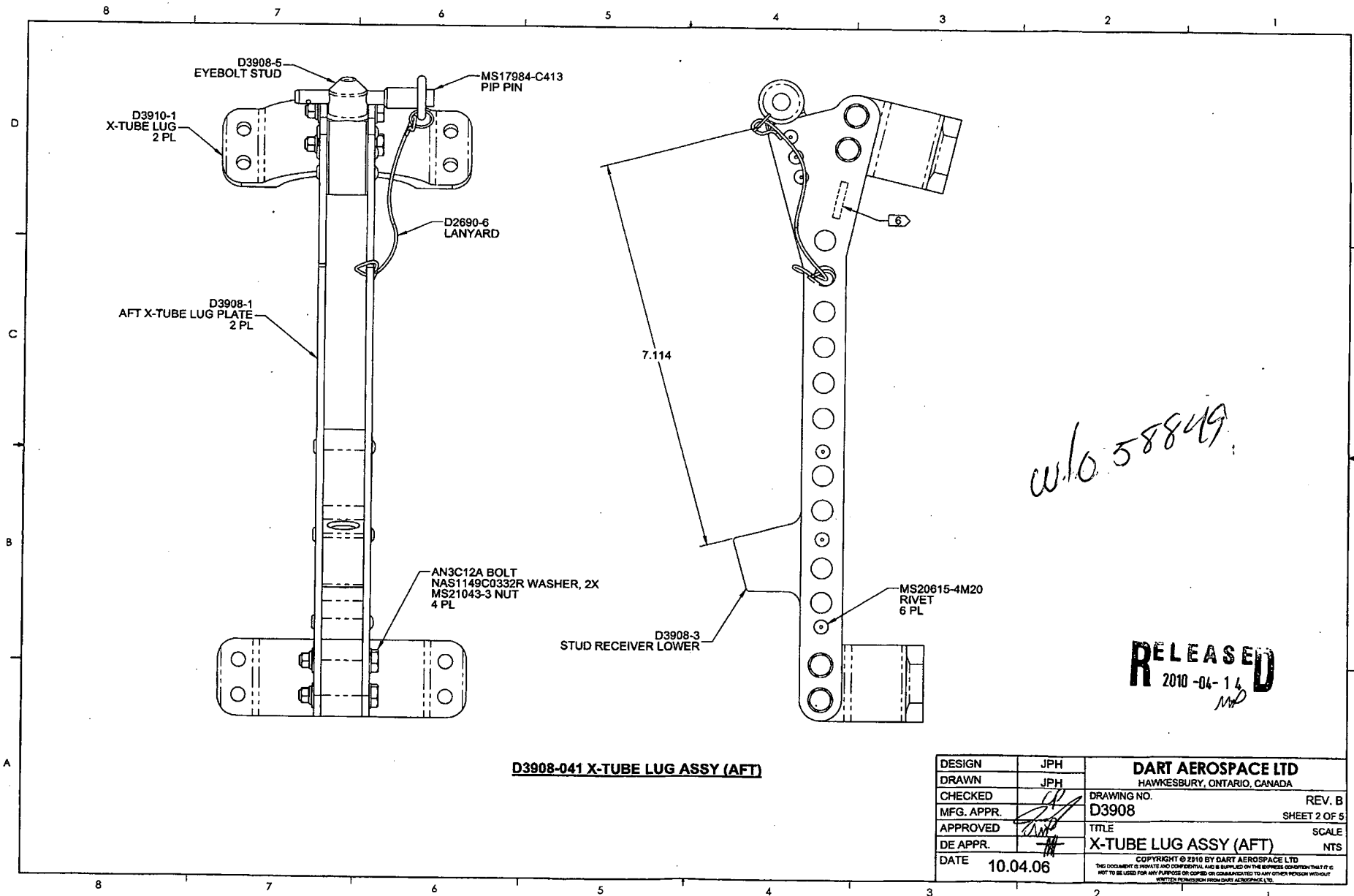
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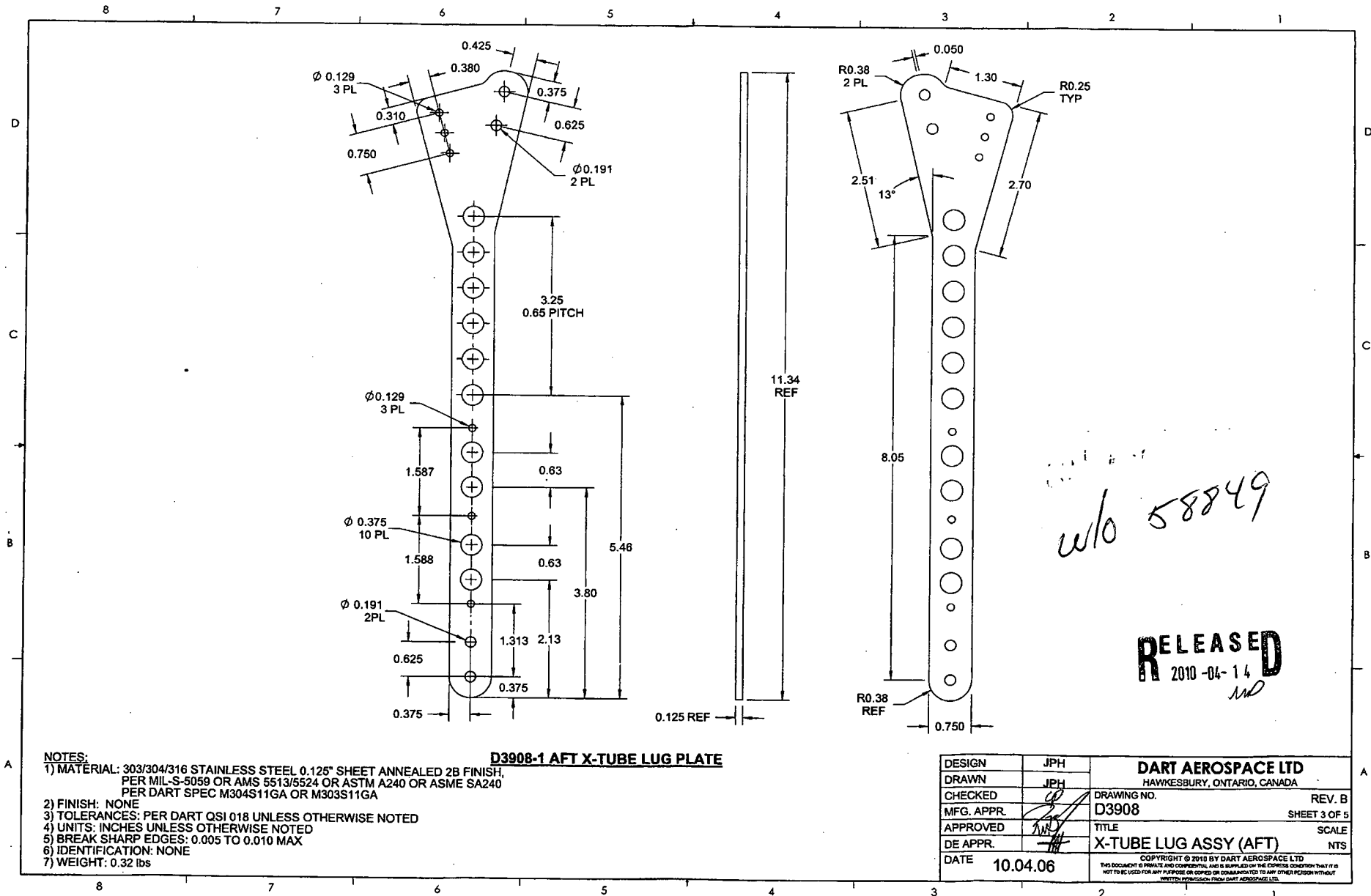
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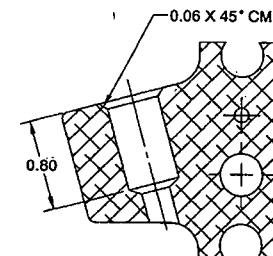
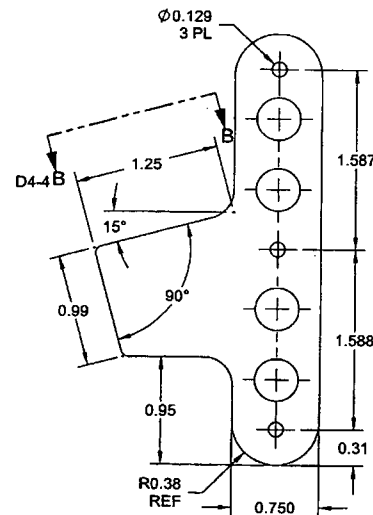
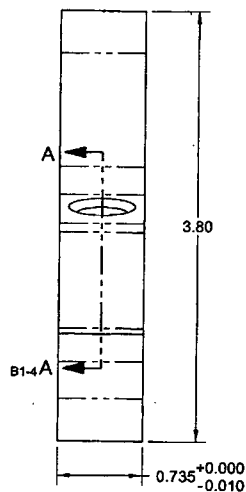
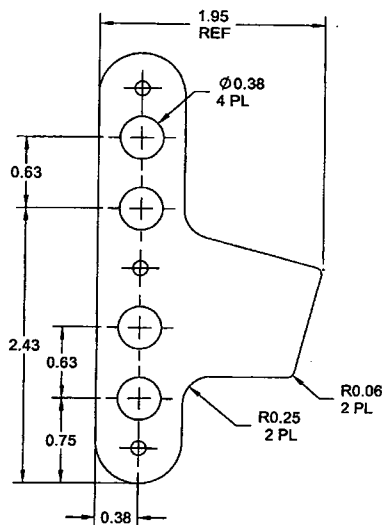
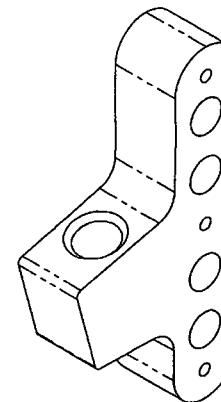
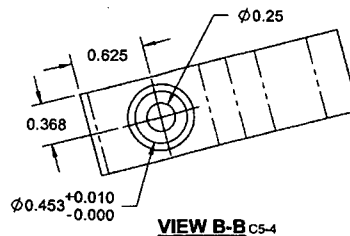
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



SECTION A-A B6-4




D3908-3 STUD RECEIVER LOWER

RELEASED
2010-04-14
MP

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.69 lbs

wb 58849

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO.	REV. B
MFG. APPR.		D3908	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG ASSY (AFT)	NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

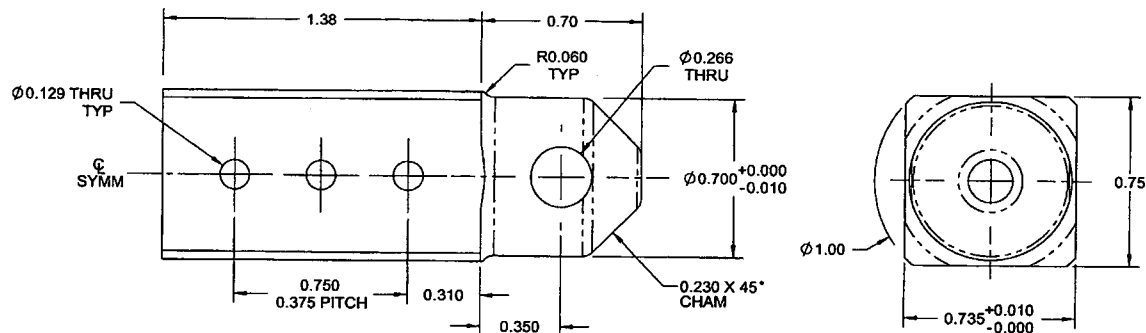
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NOTE: Date & initial all entries



B

NOTES:
 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
 PER DART SPEC M303R OR M304R
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 0.26 lbs

RELEASED
2010-04-14

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3908 TITLE X-TUBE LUG ASSY (AFT) COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR CONTAINED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	REV. B
DRAWN	JPH		SHEET 5 OF 5
CHECKED	<i>[Signature]</i>		SCALE
MFG. APPR.	<i>[Signature]</i>		NTS
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	10.04.06		

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